

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012518**Date Inspected:** 11-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Du Zhi Qun, Li Lin.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 10, South Tower, Lift 4, Skin A, AE Corner, Fitlug.

FCAW welding of weld joint SSTL4-1F/L-103; located on Bay 10, South Tower. Welders are identified as 066477; ZPMC Quality Control Inspector (QC) is identified as Li Lin. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2333-TC-P4-F.

Bay 10, South Tower, Lift 4, Skin A, AE Corner, Fitlug.

FCAW welding of weld joint SSTL4-1G/L-31; located on Bay 10, South Tower. Welders are identified as 066263; ZPMC Quality Control Inspector (QC) is identified as Li Lin. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2333-TC-P4-F.

Bay 10, North Tower, lift 4, C/D Corner Seam (Inside).

SMAW "Fifth time" Repair welding of weld joint NSTL4-3B/L-1B (CWR # T-CWR533); located on Bay 10, North Tower, lift 4. Welders are identified as 052930; ZPMC Quality Control Inspector (QC) is identified as Du Zhi Qun. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-345-SMAW-1G(1F)-REPAIR. The attached photographs provide additional detail.

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Tower Trial Assembly(Heavy Dock), South Tower, Lift 2.

Welding Temporary Platform for the tower in process. The attached photographs provide additional detail.

Bay 10, North Tower, lift 2, Skin D.

ZPMC Performing Basemetal Repairs on North Tower Lift 2. ZPMC have temporary Weld Repair Report (WRR) for these repairs. The Repairs found by Visual & Magnetic Particle Testing(VT & MT). The attached photographs provide additional detail.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

ZPMC NDT Notification # 005203.

Due to Rain Inspection area was wet. This QA informed AB/F Inspector "Li Ke Wei" & ZPMC QC "You Qi Guo" present on site about this. Inspection not done.

This QA inspector also informed lead Inspector "William Clifford" about this issue.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest Phone# 15000422360., who represents the Office of Structural Materials for your project.

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Inspected By:	Juvekar,Amit	Quality Assurance Inspector
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Reviewed By:	Clifford,William	QA Reviewer
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